

Work Order ID 162529

Monday, June 05, 2017 9:29:43 AM

162529

Ship Aug 8

Page 1

Item ID: D4406-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Wearplate Assembly

Start Date: 6/8/2017

Start Qty: 200

2

Cust Item ID:

Required Date: 6/15/2017

Req'd Qty: 200

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: JUN 07 2017

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4406

D

150

0.00

150

Large Fab

Memo

1.28

Large Fab

1- Weld D4407-041 to wearplate as per dwg D4406

304 S.S. Welding Rod

BATCH #: M154992

2- Transfer drill holes in bar

4 Q.L. 17-08-08

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

4 AUG 08 2017

DAS
24
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
								OTHER :	

Work Order ID 162529

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162529

Page 2

Item ID: D4406-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Wearplate Assembly
Start Date: 6/8/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/15/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165 *165* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				4			DAS 38 9-88 AUG 09 2017
170 *170* Small Fab Small Fab	QC5- Inspect part completeness to step on W/O Memo Apply coating as per dwg D4406	0.00 2.38				4			J-G-N
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				4			DAS 38 9-88 AUG 10 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Work Order ID 162529***162529***

Page 3

Monday, June 05, 2017 9:29:43 AM

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Revision ID: Stop ***NS2***
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Required Date: 6/15/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
100						2X	DAS		
Packaging	Memo	0.02					28		AUG 10 2017
Packaging	LOCATION : FP002 X2						9-89		
200	QC21- Final Inspection - Work Order Release	0.00					DAS		
200							21		AUG 18 2017
QC	Memo	0.20					9-89		
Quality Control									
						DAS			AUG 10 2017
						21			
						9-89			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Monday, June 05, 2017 9:29:42 AM

Page 1

Work Order ID: 162529

162529

Parent Item: D4406-041

D4406-041

Parent Item Name: Fwd Wearplate Assembly

Start Date: 6/8/2017

Required Date: 6/15/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD IPP rev B
12.02.06 as per dwg revPB1 DD verf:EC IPP REV:C 15.11.16
AS PER PD1 DD VERF:JLM IPP REV:D 16.02.05 AS PER
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4406-1 *D4406-1* Plate		Manufactured	No			150	Each	8.0000	1	2			
									**			Q.L 17-08-08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA001				8					
				152284				8				4	
D4407-041 *D4407-041* Bar Weldment		Manufactured	No			150	Each	12.0000	1	2			
									**			Q.L 17-08-08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				12					
				152248				12				8	

DQA: _____ Date: _____



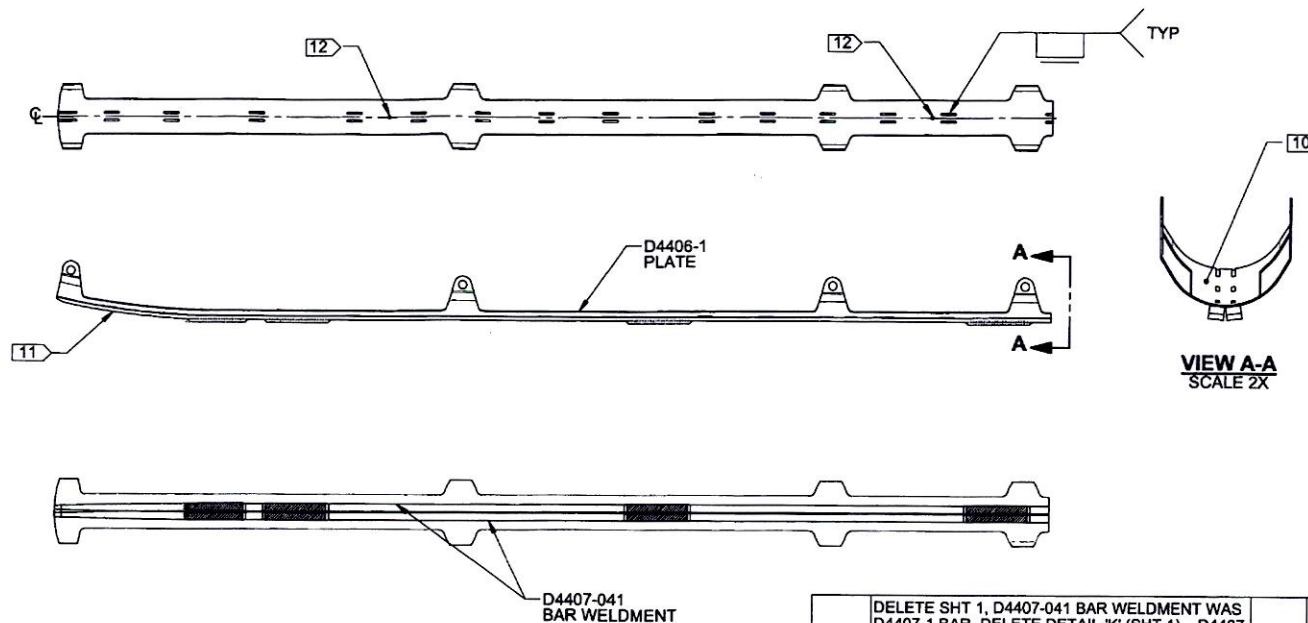
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due								
		OTHER :							

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4406-041	FWD WEARPLATE ASSY
1	1	D4406-1	PLATE
2	2	D4407-041	BAR WELDMENT



D4406-041 FWD WEARPLATE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162529 MJS
1706-07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) N/A
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING.
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-041

D	DELETE SHT 1, D4407-041 BAR WELDMENT WAS D4407-1 BAR, DELETE DETAIL 'K' (SHT 1), D4407-043 BAR WELDMENT WAS D4407-3 BAR, DELETE DETAIL 'L' (SHT 2), REMOVE NOTE 9 (SHT 1&2), NOTE 10; TEXTURED COATING WAS ROCKGUARD (SH 1&2), NOTE 12; D4407-041 WAS D4407-1 (SHT 1), D4407-043 WAS D4407-3 (SHT 2), REMOVE NOTE 13 (SHT 1&2)	DB	15.10.14
C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED, SHT 5 FWD SLOT SIZES WERE 0.88 (REF NCR12-2031)	AJS	13.03.11
B	REVISE BILL OF MATERIAL; ADD NOTE 13/14 & REVISE NOTE 9 SHT 2&3; MODIFY DETAIL E & F (ZN B3-6, C2-6); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	DB		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	15.10.14		

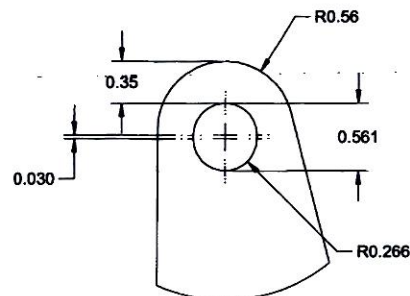
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4406** REV. D
SHEET 1 OF 5
TITLE **WEARPLATE ASSY** SCALE NTS

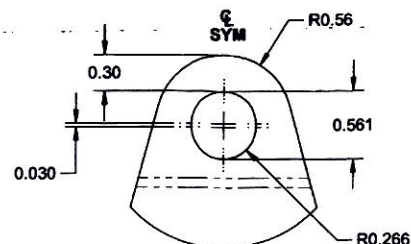
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2016-02-08
ERN 16-51B

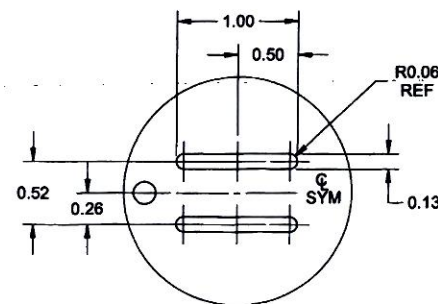
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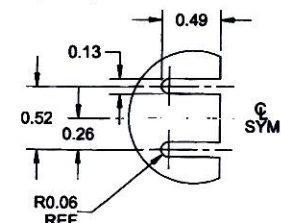
DETAIL G
SCALE 6X



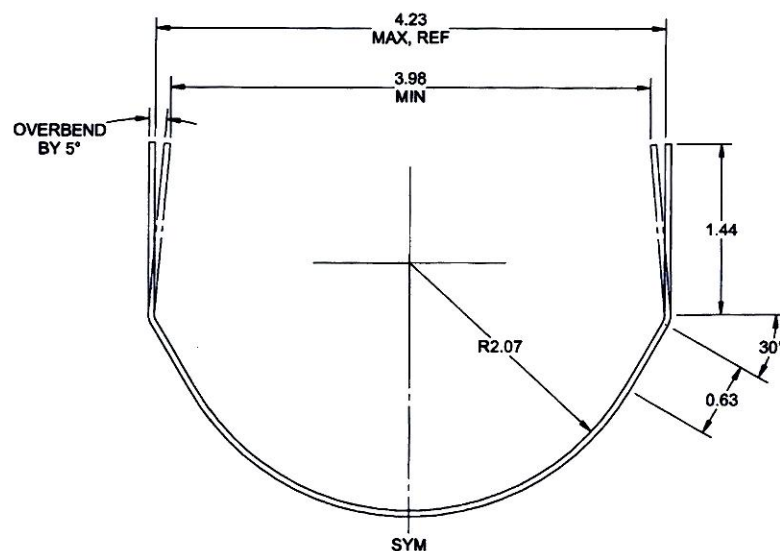
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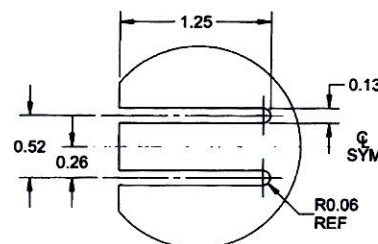
DETAIL E
SCALE 6X



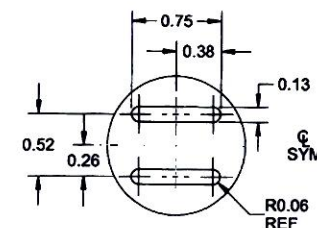
DETAIL F
SCALE 6X



DETAIL C
DETAIL TYP
SCALE 6X



DETAIL H
SCALE 6X



DETAIL J
SCALE 6X

RELEASED
2016-02-08

APPROVED

DESIGN	RF
DRAWN	DB
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	15.10.14

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D4406

TITLE
WEARPLATE ASSY

REV. D

SHEET 5 OF 5

SCALE
NTS

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